Electric Swing Clamps

Top flange, position and clamping force monitoring, IO-Link connection optional DC voltage 24 V, minimum energy demand

Application

Electric swing clamps are used for clamping or holding of workpieces
- when the clamping and holding points shall be free for loading and unloading of the fixture
- when an extended functionality is required for automated systems
- when clamping elements have to be controlled individually
- where the clamping force must be maintained also after the separation from the energy supply

Thus electric swing clamps are particularly suited for:
- Packaging industry
- Test systems
- Special machines
- Assembly equipments and robotics
- Automatic manufacturing systems
- Clamping fixtures with workpiece loading via handling systems

Description

The electric swing clamp is driven by a wear-resistant brushless DC motor. The motor speed is transformed by means of a gear and a threaded spindle into the swing and stroke movement of the piston rod. For swinging the clamping arm by 180°, an axial stroke of only 3 mm is required. If the clamping arm collides during the swing motion with a workpiece, the mechanism is protected against overload. The direct current motor is automatically and immediately switched off. When unclamping, the clamping arm always swings back to the off-position.

Integrated control

The electronic control for the DC motor is on a board in the housing of the electric swing clamp.

Electric connection

Power supply and signal exchange for external control are transmitted by two short cables with plug-type connector. Cable sockets are available for the customer's connection (see connection accessories).

Safe touch voltage

The used DC voltage 24 V is considered to be a "low voltage" and thus it is not dangerous for people in case of contact.

Advantages

- High clamping force
- Adjustable clamping force
- Clamping force monitoring
- Can be controlled individually or in common
- High operating safety by self-locking spindle drive
- Mechanical reclamping by Belleville springs
- Swing angle up to 180° available
- Overload protection device in the case of collisions with the clamping arm
- Electric position monitoring and extensive self-monitoring with diagnostic options
- Clamping stroke control possible
- Low voltage 24 V
- Leakage free
- Maintenance free (500,000 cycles).
- Code class IP 67

Power supply

For motor and electronic control a DC voltage of 24 V with a residual ripple of max. 10 % is required.
For the DC motor, we recommend the use of a switching power supply with a current output of 15 A per connected electric swing clamp. When operating several swing clamps at the same time, the line is to be enlarged correspondingly.
The electronic control has to be supplied by a separate power supply (24 V DC / 100 mA).

Adjusting ranges

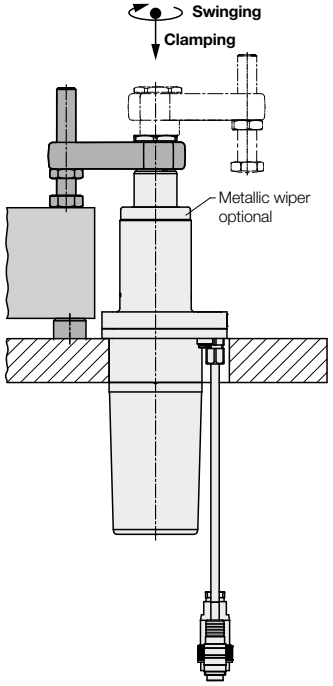
After removal of the protection cover, the following adjustments can be made on the control board:
- Clamping force
- Swing speed
- Compensation of the clamping arm elasticity

The clamping force can also be adjusted via analogue input.

Important notes!

Electric swing clamps are designed exclusively for clamping or holding of workpieces in industrial applications. They can generate very high clamping forces. The workpiece, the fixture or the machine must be in the position to compensate these forces.
In the effective area of piston rod and clamping arm, there is the danger of crushing.
The manufacturer of the fixture or the machine is obliged to provide effective protection devices.
During loading and unloading of the fixture and during clamping a collision with the clamping arm has to be avoided.
For the positioning of workpieces, the admissible displacement force as per diagram on page 3 has to be considered.
If there is any danger that fluids penetrate into the electric swing clamp, the screw plug at the venting port G 1/8 has to be removed and a vent hose has to be connected. The other end of the hose has to be placed to an absolutely dry area.
It is recommended to connect a dry positive air pressure protection with 0.2 bar.

Functional principle



Function control

Unclamped
- Clamping arm in off-position and unclamping process completed

Clamped
- Clamping arm within clamping area and clamping force obtained
- Clamping stroke control possible by output signal

Diagnostic options
- Extensive review on error conditions
- Signalling via error code (flashing signal) internally on control board or via external interface signal
- Error messages can be reset
- Review display after 500,000 cycles

You will find a complete description in the supplied operating manual.

Use IO-Link
Universal · Smart · Easy

Optionally with cable and 4-pin connector for connection to an IO-Link master. Via this interface, commands and information are exchanged between the electric swing clamp and a higher-level control.

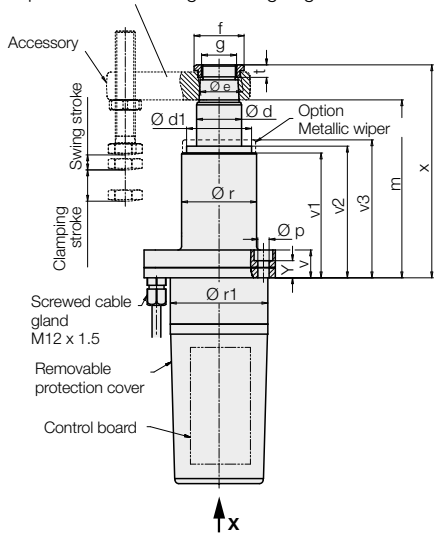
Advantages

- Reduced cabling effort
- Simplified commissioning
- More extensive diagnostic options
- Interference immunity through digital signal transmission
- All settings can be made conveniently via the IO-Link interface

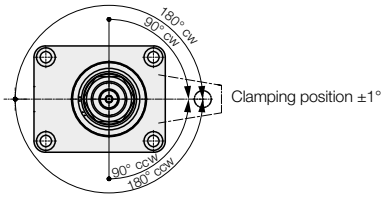
Technical information

Further information on the application and operating conditions is available on request.

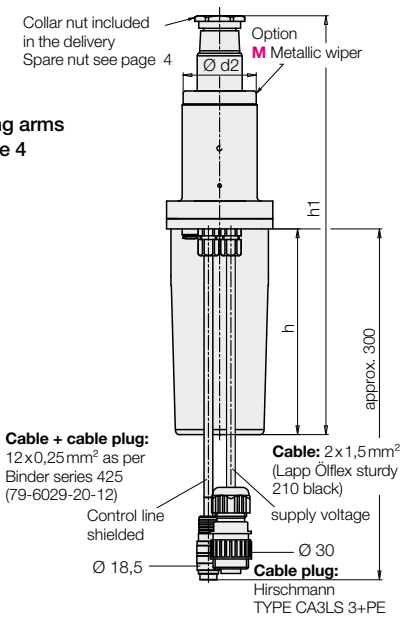
Off-position for 180 degree swing angle



Clamping arm can be fixed in any desired position.

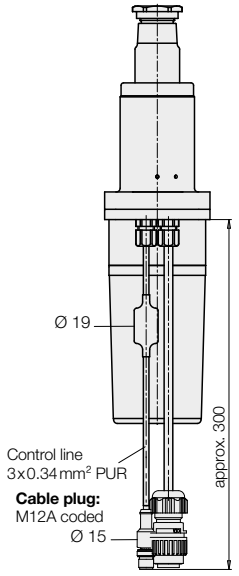


1835 CXXX X26
1835 CXXX X26M

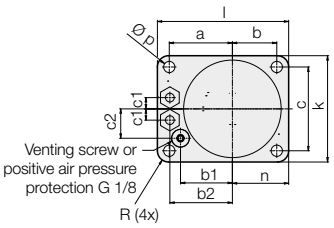


Clamping arms
see page 4

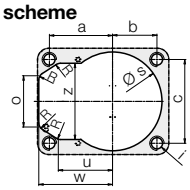
IO-Link connection
1835 CXXX X260I
1835 CXXX X26MI



View X



Connecting scheme



Connection accessories

Cable socket Binder 423 12 POL.
Part no. 3141992

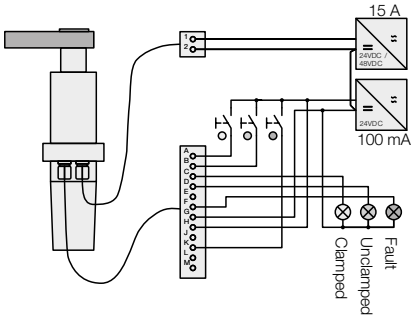
Cable socket Hirschmann CA3LD
Part no. 3141991

Connecting cable

for supply of the DC motor

Cable length	Cable cross section
< 12 m	2 x 1.5 mm²
< 20 m	2 x 2.5 mm²
< 30 m	2 x 4 mm²

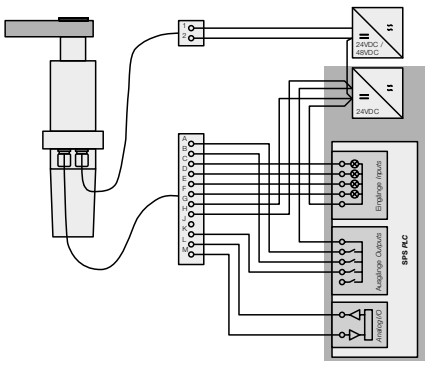
Connecting examples
Minimum configuration



Supply voltage 24 VDC -15A
1 +24 VDC
2 GND (ground)

Control line
Pin Function
A Command clamping
B Command unclamping
C Message clamped
D Message unclamped
F Message error code
K Command error reset

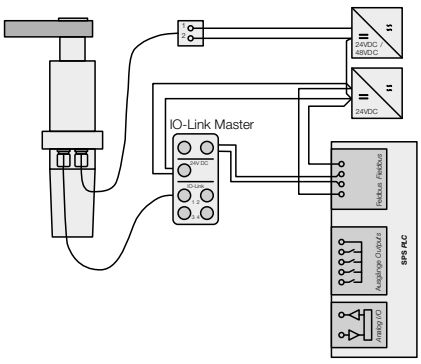
Programmable logic control PLC



Supply voltage 24 VDC - 15A
Pin Function
1 +24 VDC
2 GND (ground)

Control line
Pin Function
A Command clamping
B Command unclamping
C Message clamped
D Message unclamped
E Message number of cycles
F Message error code
G GND (ground)
H +24VDC (control)
K Command error reset
L Analogue input clamping force (0–10 V)
M Analogue output clamping stroke (0–10 V)

IO-Link connection



IO-Link connection
Supply voltage 24 VDC -15A
1 +24 VDC
2 GND (ground)

Control line
1 +24 VDC
3 GND (ground)
4 C/Q IO-link

Use IO-Link
Universal · Smart · Easy

Electric swing clamps		1835
Axial pulling force adjustable	[kN]	3....9
Effective clamping force	[kN]	see diagram
Admissible displacement force	[kN]	see diagram
Clamping stroke (usable)	[mm]	20
Swing stroke	[mm]	3
Total stroke (mechanical)	[mm]	26
Swing angle	[°]	0°/90°/180° *
Clamping time approx.	[s]	3**
Unclamping time approx.	[s]	3**
Special clamping arm		
Max. clamping arm length	[mm]	150
Max. radial torque	[Nm]	0.4
Max. moment of inertia	[kgm²]	0.008
Nominal voltage	[V DC]	24
Operating range	[V DC]	22.....30
Residual ripple	[%]	< 10
Max. current consumption	[A]	15
Power consumption in standby mode approx.	[W]	1.2
Duty cycle	[%]	25 (S3)
Code class		IP 67
Positive air pressure connection max.	[bar]	0.2
Ambient temperature	[°C]	–5 ....+40
Mounting position		preferably vertical***
Weight, approx.	[kg]	8
a	[mm]	50.5
b	[mm]	35.5
b1	[mm]	41.5
b2	[mm]	50
c	[mm]	67
c1	[mm]	9
c2	[mm]	23.5
Ø d	[mm]	36
Ø d1	[mm]	52
Ø d2	[mm]	58.5
Ø e	[mm]	33.5
f	[mm]	40
g	[mm]	M28 x 1.5
h	[mm]	164.5
h1	[mm]	334
i	[mm]	M8
k	[mm]	85
l	[mm]	105
m – 1	[mm]	142
n	[mm]	45
o	[mm]	41
Ø p	[mm]	9
Ø r – 0.1	[mm]	60
Ø r 1	[mm]	78
R max.	[mm]	6
Ø s ± 0.5	[mm]	79
t	[mm]	10
u	[mm]	43.4
v	[mm]	22
v1	[mm]	99.5
v2	[mm]	105
v3	[mm]	110
w	[mm]	59
x	[mm]	170
y	[mm]	13.5
z	[mm]	61

Part no.	
Swing direction 90° clockwise	**1835 C090 R26XX**
Swing direction 90° counterclockwise	**1835 C090 L26XX**
Swing direction 180° clockwise	**1835 C180 R26XX**
Swing direction 180° counterclockwise	**1835 C180 L26XX**
0 degree	**1835 C000 026XX**

XX = Options
0I = IO-link
M = Metallic wiper
MI = Metallic wiper + IO-link

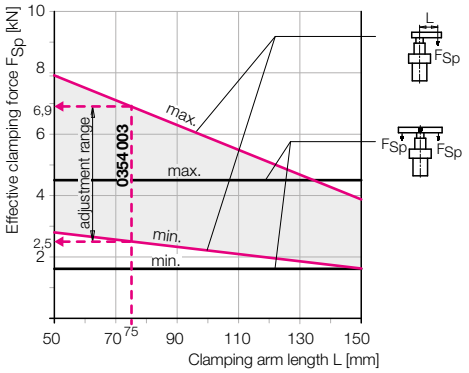
* Further swing angles are available on request (min. 45°).
** Further technical data are available on request
*** For horizontal mounting position, please note page 4.

Important note!

To guarantee a process-safe application, all technical requirements and general conditions must be carefully checked.
Please contact our technical consultants (on site or directly in product management, Tel.: +49 6405 89456).

Effective clamping force F_{Sp} as a function of the clamping arm length L

The effective clamping force is smaller the longer the clamping arm. For longer clamping arms, the clamping force must be reduced so that the admissible bending moment will not be exceeded. The adjustment of the clamping force is made on the control board or externally via the analogue input L.
The default setting of 6.9 kN is suitable for the accessory clamping arm L = 75 mm.



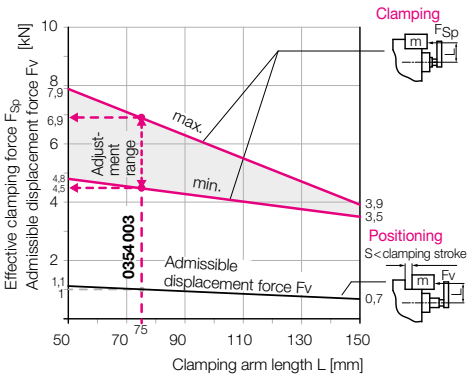
Example
Accessory clamping arm 0354 003: L = 75 mm
As per diagram:
- max. clamping force 6.9 kN
- min. clamping force 2.5 kN

The clamping force is continuously adjustable.

Admissible displacement force Fv for the horizontal positioning of a workpiece

The electric swing clamp can push, i.e. position a workpiece against fixed points.
The usable displacement force Fv is depending on the clamping arm length between 0.7 and 1.1 kN.

Conditions:
For functional reasons, the clamping force F_{Sp} must be adjusted for the subsequent clamping of the workpiece with the accessory clamping arm (L = 75 mm) to at least 4.5 kN.

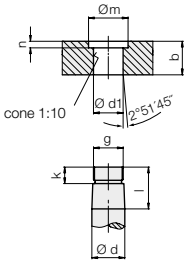


Example
Accessory clamping arm 0354 003: L = 75 mm
As per diagram:
- Min. clamping force 4.5 kN
- Max. clamping force 6.9 kN
- Displacement force Fv 1.0 kN

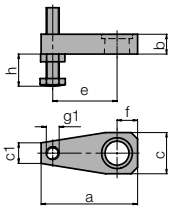
With a friction coefficient μ = 0.4, this is sufficient for a workpiece mass m:

$$m = \frac{Fv}{g * \mu} = \frac{1000\ N}{9.81 * 0.4} = 250\ kg$$

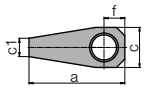
Dimensions for special clamping arms



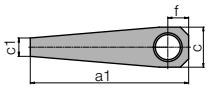
Clamping arm with contact bolt



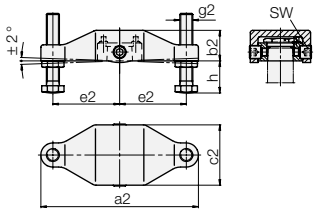
Clamping arm without thread g1



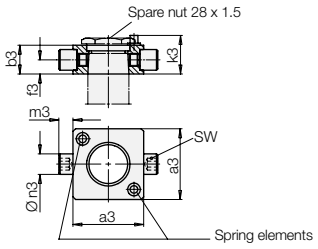
Clamping arm blank



Double clamping arm complete with carrier
GGG 40



Carrier for double clamping arm
42CrV4 hardened and tempered



Horizontal mounting position

The electric swing clamp can be operated with the accessory clamping arm 0354003 (e = 75 mm) in every mounting position.
In the case of longer and heavier special clamping arms, the admissible radial torque M1 of 0.4 Nm will be exceeded, which can lead to malfunctions and increased wear.
Remedy:
Provide the clamping arm with a counterweight as explained in the opposite example.

Electric swing clamps		**1835**
a	[mm]	115
a1	[mm]	190
a2	[mm]	196
a3 ±0.1	[mm]	55
b	[mm]	23
b2	[mm]	38
b3 ±0.1	[mm]	23
c	[mm]	48
c1	[mm]	22
c2	[mm]	75
Ød f7	[mm]	32
Ød1 +0.05	[mm]	31.85
e	[mm]	75
e2	[mm]	83
f	[mm]	25
f3	[mm]	11
g	[mm]	M28x1.5
g1	[mm]	M16
g2	[mm]	M16
h min...max	[mm]	15...79
k	[mm]	12
k3**	[mm]	29
l	[mm]	28
Ø m	[mm]	34
m3	[mm]	11
n	[mm]	5
Ø n3 g6	[mm]	16
Ø p	[mm]	90
Ø q –0.2	[mm]	68
r	[mm]	M60x1.5
s	[mm]	13
t	[mm]	4
SW	[mm]	8

Part no.		
Clamping arm with contact bolt		**0354003**
Weight, approx.	[kg]	0.8
Moment of inertia	[kgm²]	0.002295
Radial torque	[Nm]	0.32
Clamping arm without thread g1		**3921017**
Weight, approx.	[kg]	0.65
Moment of inertia	[kgm²]	0.00134
Radial torque	[Nm]	0.20
Clamping arm blank		**3548902**
Weight, approx.	[kg]	1.15
Moment of inertia	[kgm²]	0.00798
Radial torque	[Nm]	0.74
Material: High alloy steel 1000....1200 N/mm²		
Double clamping arm, complete*		**0354132**
Weight, approx.	[kg]	2
Moment of inertia	[kg·m²]	0.00765
Carrier for double clamping arm		**0354142**
Weight, approx.	[kg]	0.46
Spare nut M 28 x 1.5		**3527015**
Max. tightening torque	[Nm]	90
Weight, approx.	[kg]	0.05
Metallic wiper		**0341231**

* Complete with threaded bolt and spring elements
** Height stop surface for spring elements

Clamping arm S1 with weight compensation S2

Required counterweight $m2 = \frac{M1}{l2}$ [kg]

M1 = First-order torque around the piston axis (control of the CAD model) [kgm]
m2 = Mass of counterweight [kg]
l2 = Centre of gravity of the mass m2 [m]

Important note!
The additional counterweight increases the moment of inertia J around the piston axis, what can be easily determined by querying of the CAD model. To avoid an overload of the swing drive, the flow rate has to be reduced: The setting is described in the operating manual.

Mounting position - horizontal